



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D4785-041

Job Sheet 171887



Part No: D4785-041

Job Qty: 1 ea

Part Name: Long Basket Base Assembly, LH/RH



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 2/8/18

Job Tracking No:

Due Date: 2/16/18

Created By: Michelle Gagnon-Donovan

Type: SOLD

Description:

Note: DWG REV B SHEETS 1,2,3,4 IPP REV:A 13.03.14 NEW ISSUE DD VERF:JLM IPP REV:B 13.06.17 as per dwg rev.pb1 DD VERF:JLM IPP REV:C 13.07.04 revise bom per dwg rev.B DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		2/14/18	0.00	0.00	Start Up Large Fab-6		2018-02-29
100	Large Fab	1 pcs		2/15/18	0.00	25.00	Large Fab 1		2/18-02-24
110	QC	1 pcs		2/15/18	0.00	0.00	QC9		CPC
120	QC	1 pcs		2/15/18	0.00	0.00	QC5		CPC
125	HandFinish	1 pcs		2/15/18	0.00	0.52	HandFinish2		2/18-2-27
130	Powdercoat	1 pcs		2/15/18	0.00	0.84	Powdercoat2		2/18-2-27
140	QC	1 pcs		2/15/18	0.00	0.00	QC3		2/18-2-27
150	HandFinish	1 pcs		2/16/18	0.00	0.52	HandFinish4		2/18-2-27
160	QC	1 pcs		2/16/18	0.00	0.00	QC5		2/18-2-28
170	Packaging	1 pcs		2/16/18	0.00	0.00	Packaging3-2		2/18-2-26
180	QC21-SA	1 Ea		2/16/18	0.00	0.00	QC21		21 FEB 28 2018

Part Op 100 - 1- Use DT9610A to assemble contour ribs and the (2) D3916-5 ribs , weld as per dwg D4785 ***ENSURE BOTTOM
Descriptions: OF BASE RIB ARE STRAIGHT*** 2-Cut D4020-1 base mesh and tack weld all mesh on basket as per dwg D4785 and
trim mesh to fit if necessary and trim to clear fasteners holes on the ends ***USE DT10158 WITH SHIM WHEN
WELDING BOTTOM OF RIB D4785-115*** 3- weld hinge (3) and Mounting brackets as per dwg D4785
110 - ***ENSURE BOTTOM OF BASE RIB ARE STRAIGHT*** Use DT10160 jig to ensure D4785-115 holes are align
after welding
120 - ***ENSURE BOTTOM OF BASE RIB ARE STRAIGHT***
130 - 1- Plug holes and mask only interior of hinge (3) prior to powder coat
150 - Pick kit and assemble

M138467- START: 3:25. O.V.T: 3:35. FINISH: 3:40.

M M.O. 953

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2581	Mounting Bracket	2 Ea (2 ea)	90-Start up Operation	5036037
D3913-1	Rib	1 Ea (1 ea)	90-Start up Operation	5041355
D3913-3	Rib	1 Ea (1 ea)	90-Start up Operation	5032655
D3913-9	Hinge Rib	1 Ea (1 ea)	90-Start up Operation	5030824
D3916-5	Light Rib	2 Ea (2 ea)	90-Start up Operation	5040550
D4016-1	Hinge Half, Base	3 Ea (3 ea)	90-Start up Operation	5036080
D4017-7	Rib	3 Ea (3 ea)	90-Start up Operation	5037501
D4020-11	End Mesh, Basket	2 Ea (2 ea)	90-Start up Operation	5041136
D4034-041	Aft Upper Rib Assembly	1 Ea (1 ea)	90-Start up Operation	504248
D4034-043	Fwd Upper Rib Assembly	1 Ea (1 ea)	90-Start up Operation	5042466
D4672-1	Blanking Plate	2 Ea (2 ea)	90-Start up Operation	5036909
D4785-1	Rib	2 Ea (2 ea)	90-Start up Operation	5030908
D4785-115	Rib Assembly	4 Ea (4 ea)	90-Start up Operation	5039413
D4785-117	Rib Assembly	2 Ea (2 ea)	90-Start up Operation	5042429
D4785-3	Rib	2 Ea (2 ea)	90-Start up Operation	5030183
D4785-5	Rib	3 Ea (3 ea)	90-Start up Operation	5006611
D4793-1	Handle Plate	3 Ea (3 ea)	90-Start up Operation	5030862 → 2x
D4793-3	Handle Plate, Wide	1 Ea (1 ea)	90-Start up Operation	50414943 → 1x
M304EX0.75-16F	Expanded Metal Flat SS	33 sf (33 ea)	90-Start up Operation	504189
AN3-10A	Bolt	6 Ea (6 ea)	150-HandFinish	5041477
D2931	Bumper	2 Ea (2 ea)	150-HandFinish	5064355
D4021-5	Blanking Plate	2 Ea (2 ea)	150-HandFinish	50415376
MS20600-AD4W3	Cherry Rivet	2 Ea (2 ea)	150-HandFinish	5042091
MS21042L3	Nut	6 Ea (6 ea)	150-HandFinish	5037284
NAS1149DN832J	Washer	2 Ea (2 ea)	150-HandFinish	50137587-12
NAS1149F0332P	Washer	12 Ea (12 ea)	150-HandFinish	5020603

001257

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D2581	2	68	0
	D3913-1	1	6	0
	D3913-3	1	9	0
	D3913-9	1	8	0
	D3916-5	2	26	0
	D4016-1	3	83	0
	D4017-7	3	69	0
	D4020-11	2	0	0
	D4034-041	1	5	0
	D4034-043	1	5	0
	D4672-1	2	52	0
	D4785-1	2	2	0
	D4785-115	4	4	0
	D4785-117	2	2	0
	D4785-3	2	3	0
	D4785-5	3	7	0
	D4793-1	3	8	0
	D4793-3	1	13	0
	M304EX0.75-16F	33	459	0
150-HandFinish	AN3-10A	6	60	0
	D2931	2	1,144	0
	D4021-5	2	11	0
	MS20600-AD4W3	2	159	0
	MS21042L3	6	3,757	0
	NAS1149DN832J	2	2,588	0
	NAS1149F0332P	12	3,827	0

Part Specifications

Specifications could not be found.

Plex 2/8/18 4:04 PM Dart.Gagnon.Michelle

Master Unit 000953



Job No 171887



Container No: S045407



Part: D4785 - 041

Job No: 171887

Serial No/Batch: S045407

Revision: D4785

Inspector:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K64 1K7
CANADA
TEL.: 1 813 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

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